

Date: Monday, 2/19/2007 8:07:53 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GASKET
Job Number	: 30754		
Estimate Number	: 12720		
P.O. Number	: N/A	Part Number	: D353623 <i>Rev A</i>
This Issue	: 2/19/2007 S.O. No. : N/A	Drawing Number	: D3536 <i>UNDER REVIEW PH 07.02.19</i>
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: U/R
Previous Run	: N/A	Material	: N/A
Written By	: <i>[Signature]</i>	Due Date	: 2/26/2007
Checked & Approved By	: <i>[Signature]</i> 07.02.19	Qty:	12 Um: Each
Comment	: Est Rev: A New Issue 07-02-14 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MNEO60S063	NEOPRENE SHEET 0.063
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Comment: Qty.: 1.4033 sf(s)/Unit Total : 16.8399 sf(s)

NEOPRENE SHEET 0.063

Batch: *M103104*

SAD 07/03/10

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3536

Dwg Rev: *A*

Prog Rev: *A*

[Signature] *SAD 07/03/10*

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/03/10

(12)

PTD

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

07/03/12 (12)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

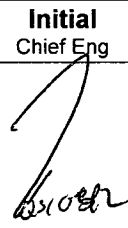

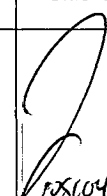

Identify and Stock

Location: _____

[Signature] *07/03/13 (12)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: FD Date: 07/03/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/02/10 SAD	2.0	water jet didn't cut one correctly "Scrap one piece"		Scrap and destroy replace	07/02/10 SAD	 07/03/12	 06/04/12	 07/03/12

NOTE: Date & initial all entries

Date: Monday, 2/19/2007 8:07:53 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 30754

Part Number: D353623

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(12)

20070314

Job Completion



U 07-03-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

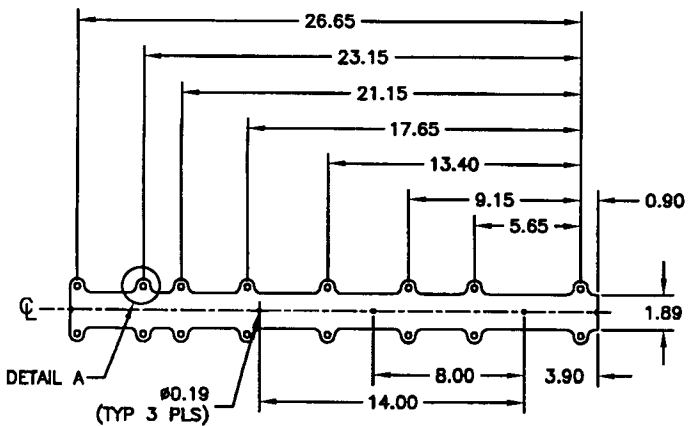
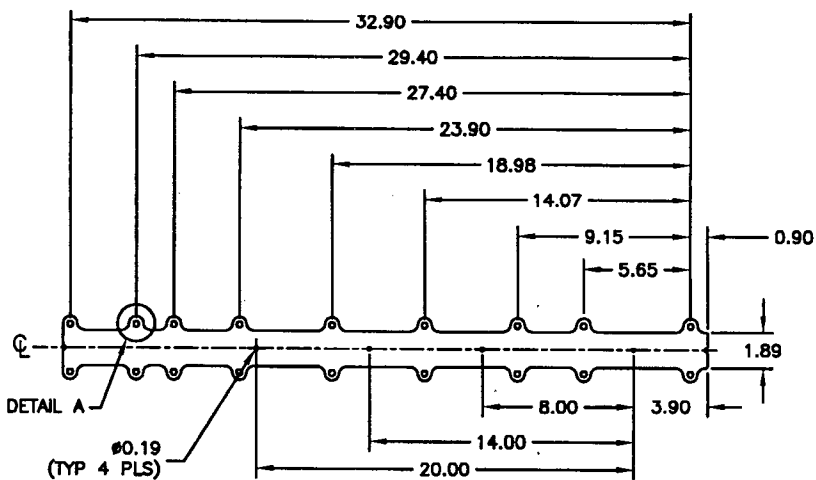
NOTE: Date & initial all entries

DART

RELEASED

09.02.12

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
A	06.10.25	GASKET	NEW ISSUE	SHEET 1 OF 6
				SCALE 1:10

**D3536-11 GASKET****D3536-13 GASKET**

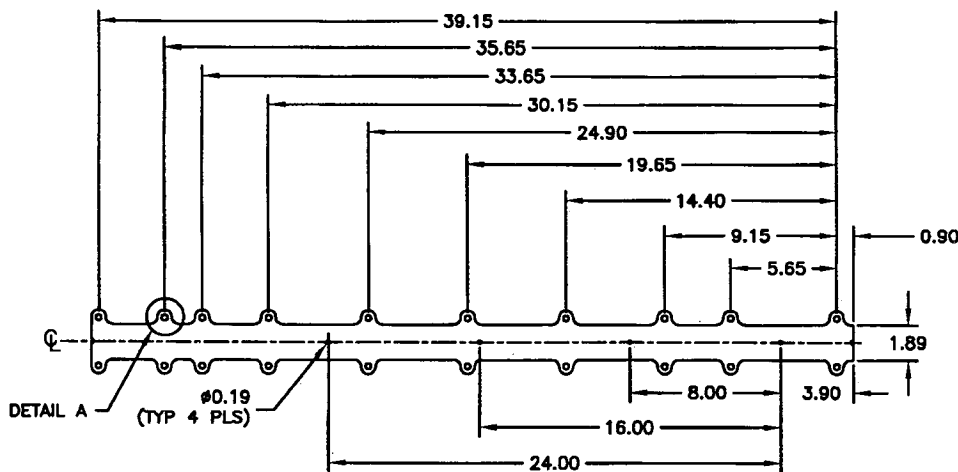
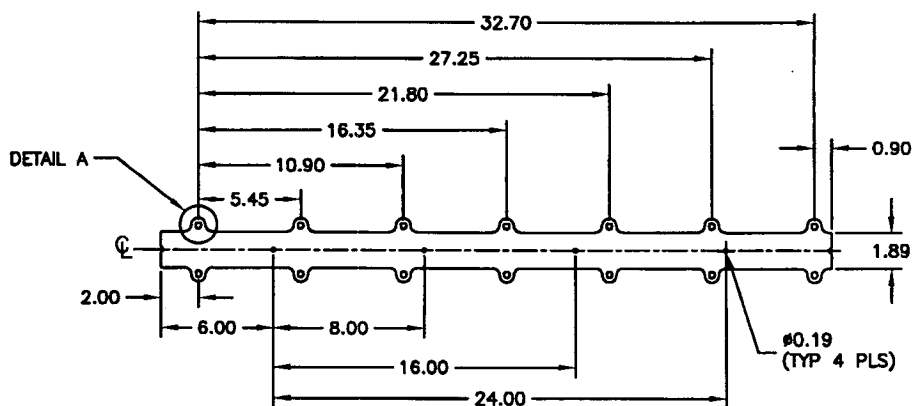
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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30754

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

DART

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.	REV. A
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA	
DATE	06.10.25	DRAWING NO.	D3536	TITLE	GASKET
					SHEET 2 OF 6
					SCALE 1:10

RELEASED
07.02.12**D3536-15 GASKET****D3536-21 GASKET**

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WORK ORDER
NO. 30754

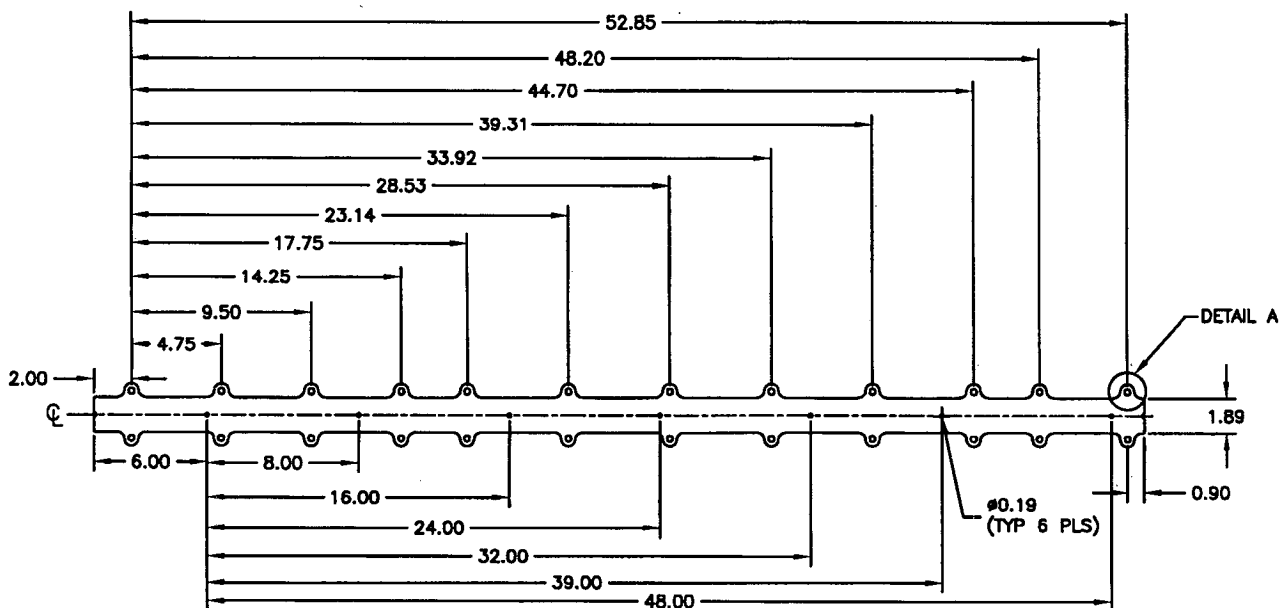
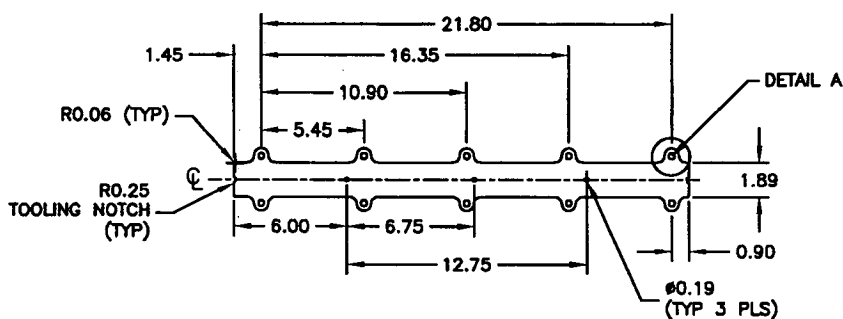
NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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DART

DESIGN	C.B.	DRAWN BY	C.B.	DART AEROSPACE USA, INC.	REV. A
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA	
DATE	06.10.25	TITLE	GASKET	DRAWING NO.	D3536
				SHEET 3 OF 6	
				SCALE	1:10

RELEASED
07.02.12

**D3536-23 GASKET****D3536-25 GASKET****NOTES**

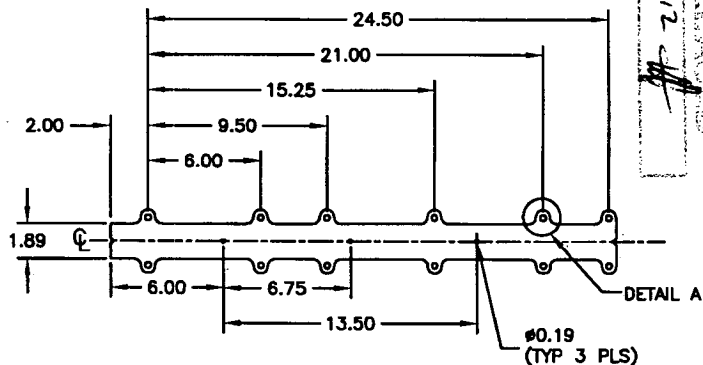
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
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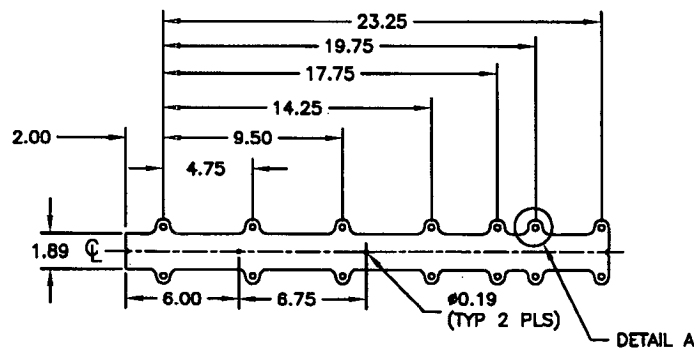
DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED PH	DRAWING NO. D3536	REV. A
DATE 06.10.25	TITLE GASKET	SHEET 4 OF 6	
		SCALE 1:10	

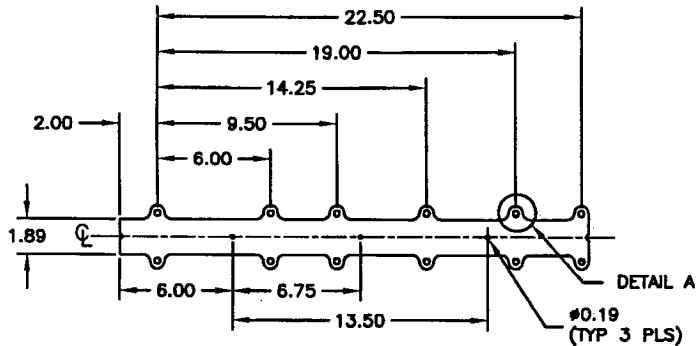
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D3536-33 GASKET



D3536-35 GASKET



D3536-31 GASKET

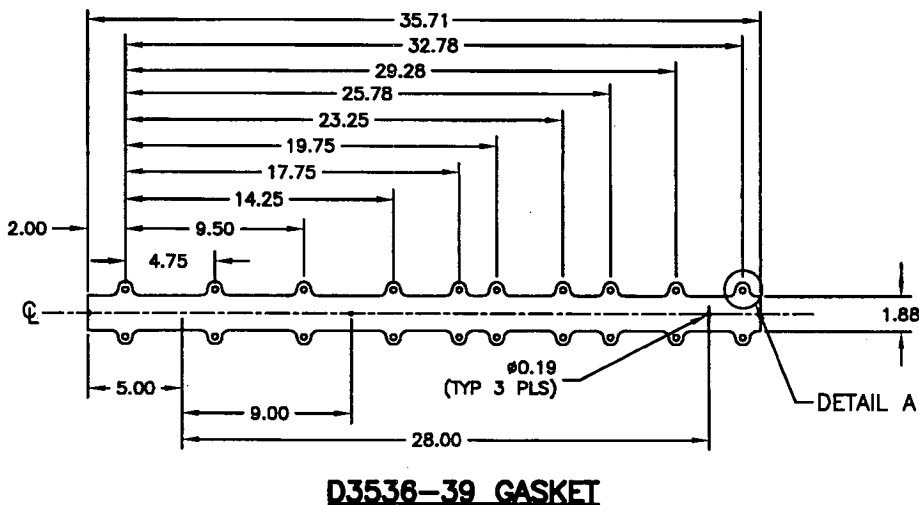
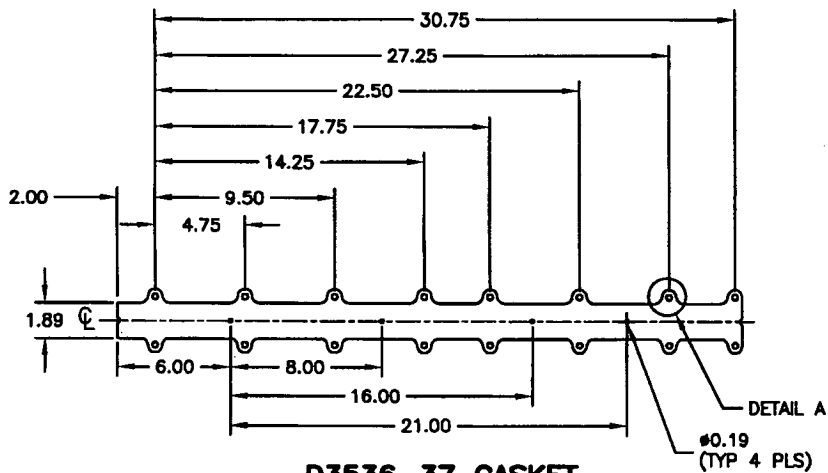
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- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
 - 2) FINISH: NONE
 - 3) PART IS SYMMETRICAL ABOUT C
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DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED PH	DRAWING NO. D3536	REV. A
DATE 06.10.25	TITLE GASKET	SHEET 5 OF 6	SCALE 1:10

07.02.02 **PH**



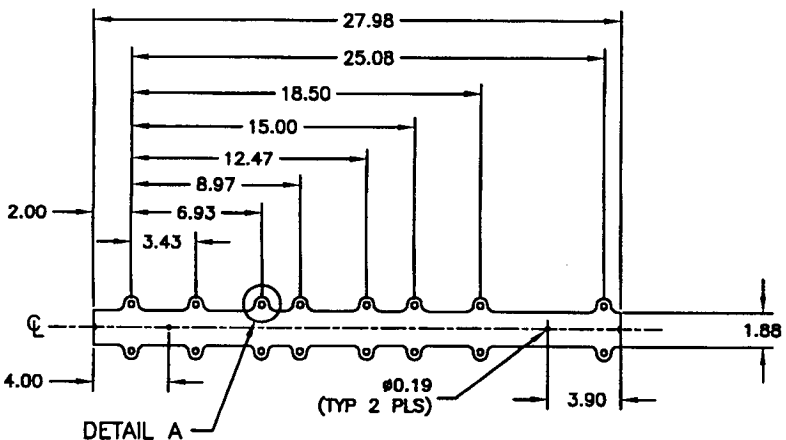
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WORK ORDER
NO. **30754**

- NOTES**
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CHECKED PH	APPROVED PH	DRAWING NO. D3536	REV. A
DATE 06.10.25		TITLE GASKET	SHEET 6 OF 6
			SCALE 1:10

RECEIVED
07.02.12
CH

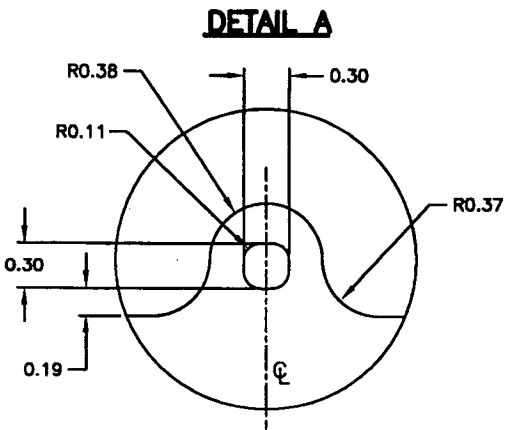


D3536-41 GASKET

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NO. 30754

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DART AEROSPACE LTD		Work Order: 30754
Description: basket		Part Number: D3536-23
Inspection Dwg: A	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
52.85	+/- 0.030	52.875	✓		M-T / Vern	
48.20	+/- 0.030	48.220	✓		M+T	
44.70	+/- 0.030	44.68	✓		M-T / Vern	
39.31	+/- 0.030	39.50	✓		M-T / Vern	
33.42	+/- 0.030	33.95	✓		M-T / Vern	
28.53	+/- 0.030	28.56	✓		M-T / Vern	
23.14	+/- 0.030	23.170	✓		M-T / Vern	
17.75	+/- 0.030	17.75	✓		M-T	
14.25	+/- 0.030	14.25	✓		M-T	
9.50	+/- 0.030	9.50	✓		M-T	
4.75	+/- 0.030	4.75	✓		M-T	
8.00	+/- 0.030	8.02	✓		Vern	
16.00	+/- 0.030	16.02	✓		Vern	
24.00	+/- 0.030	24.02	✓		Vern	
32.00	+/- 0.030	32.01	✓		Vern	
39.00	+/- 0.030	39.01	✓		Vern	
47.00	+/- 0.030	47.00	✓		Vern	
Ø 0.19	+/- 0.030	Ø 0.193	✓		Vern	
Ø 0.30	+/- 0.030	0.317	✓		Vern	
0.30	+/- 0.030	0.317	✓		Vern	
1.89	+/- 0.030	1.91	✓	✗	Vern	

Measured by: SAD	Audited by:	Prototype Approval:
Date: 07/03/10	Date:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	